



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

*WAST SHIP
JAN 30*

D5469-1
Job Sheet 171080



Part No: D5469-1

Job Qty: 2 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 1/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/29/18	0.00	0.00	Start Up Machining-4		<i>FK 18-1-29</i>
100	CNC Vertical Machining	2 pcs		1/29/18	0.00	3.96	HAAS1-1		<i>FK 18-1-29</i>
120	QC	2 pcs		1/29/18	0.00	0.00	QC2 Machining-4		<i>FK 18-1-29</i>
130	QC	2 pcs		1/29/18	0.00	0.00	QC8 Machining-4		<i>FK 18-1-29</i>
140	HandFinish	2 pcs		1/29/18	0.00	0.28	HandFinish1		<i>2018/01/30 JSL</i>
150	SprayPaint	2 pcs		1/30/18	0.00	0.05	Spray Paint		<i>2018/01/30 JSL</i>
160	QC	2 pcs		1/30/18	0.00	0.00	QC14		<i>18-01-31</i>
170	Packaging	2 pcs		1/30/18	0.00	0.00	Packaging3-2		<i>18-01-31</i>
180	QC21-SA	2 Ea		1/30/18	0.00	0.00	QC21		<i>FEB 01 2016</i>

Part Op **100** - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FB548 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp

150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	2 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	2	33	0

S036/30

Part Specifications

Specifications could not be found.

Plex 1/26/18 2:51 PM dart.lacelle.linda

PO:038908

JAN 30 2018

**DAS
13
9-50**

DART
AEROSPACE
S036171

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Aft, In

PART NO: D5469-1

Original Serial #: S036171

Revision:

Operation:

Change No:

Start up Operation 01/27/18

Job No: 171080

DART AEROSPACE LTD		Work Order: 171080
Description: Saddle, Aft Inboard DS469		Part Number: D2574 DS469-1
Inspection Dwg: D2574 Rev. A		Page 1 of 1

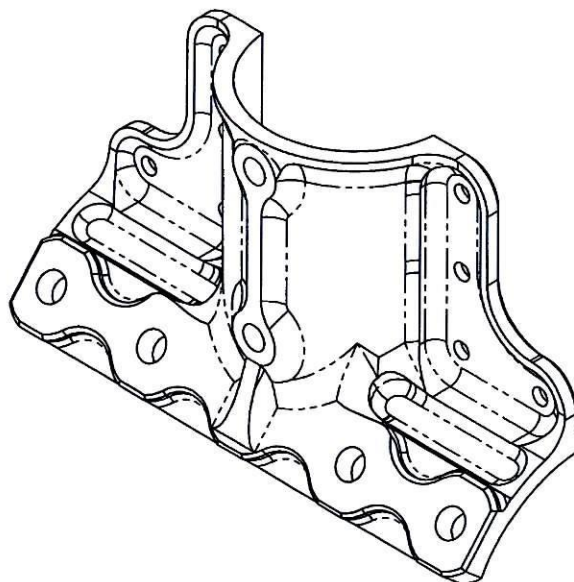
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		.500	.498				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.135	.135				
Q	0.115	0.135		.125	.125				
R	0.240	0.260		.252	.253				
S	0.115	0.135		.126	.125				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.241	.241				
W	0.115	0.135		.121	.120				
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.060	.060				
AD	0.240	0.260		.251	.251				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.250	.249				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043							
Accept/Reject				✓	✓				

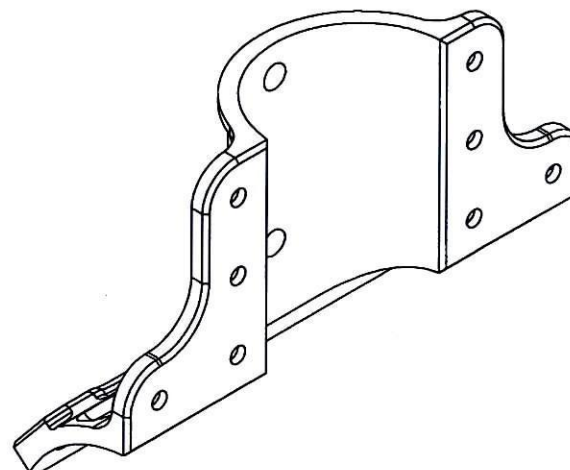
Measured by: Fk.
Date: 18-1-28

Audited by: [Signature]
Date: 18/01/30

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



171000



D5469-1 INNER AFT SADDLE

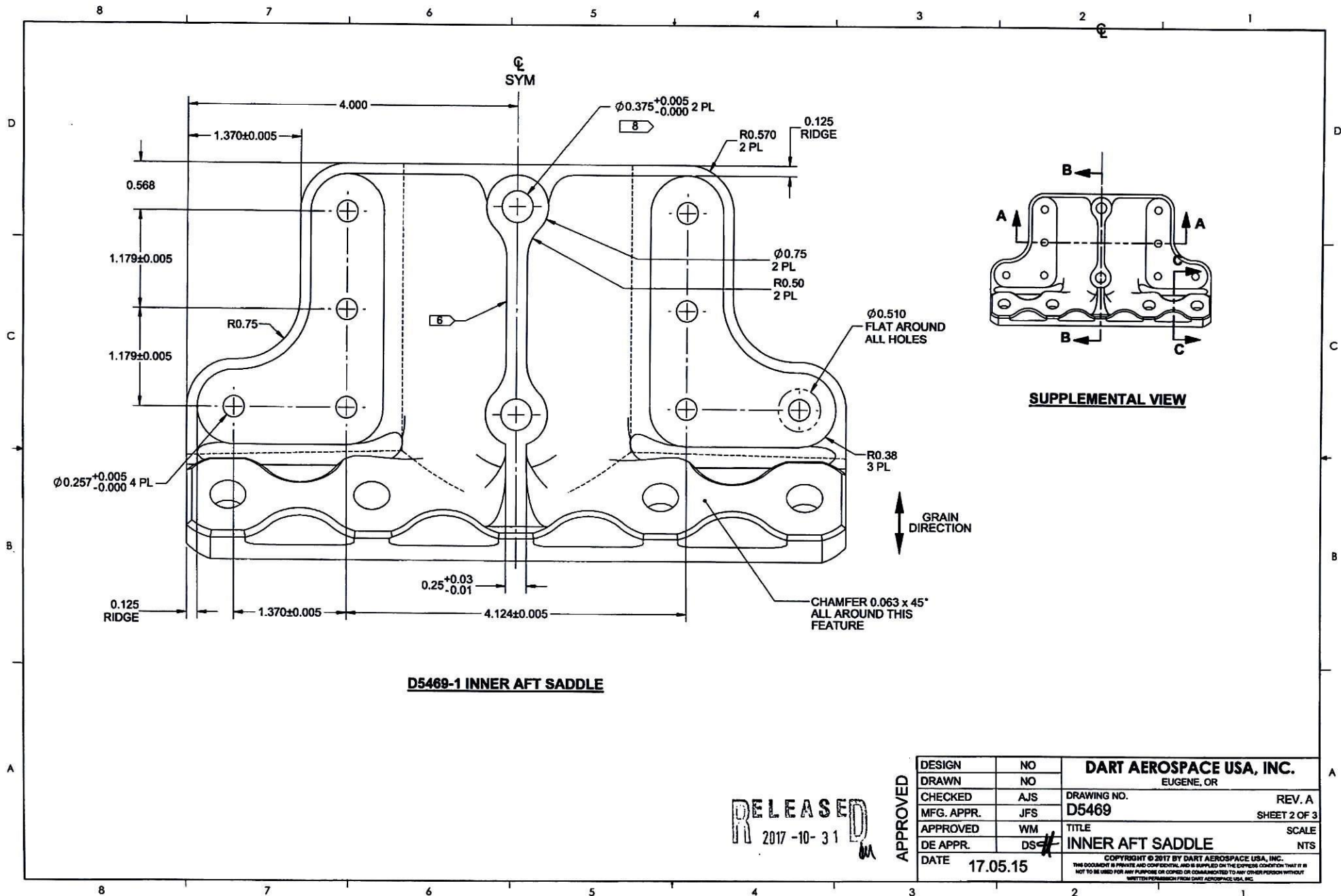
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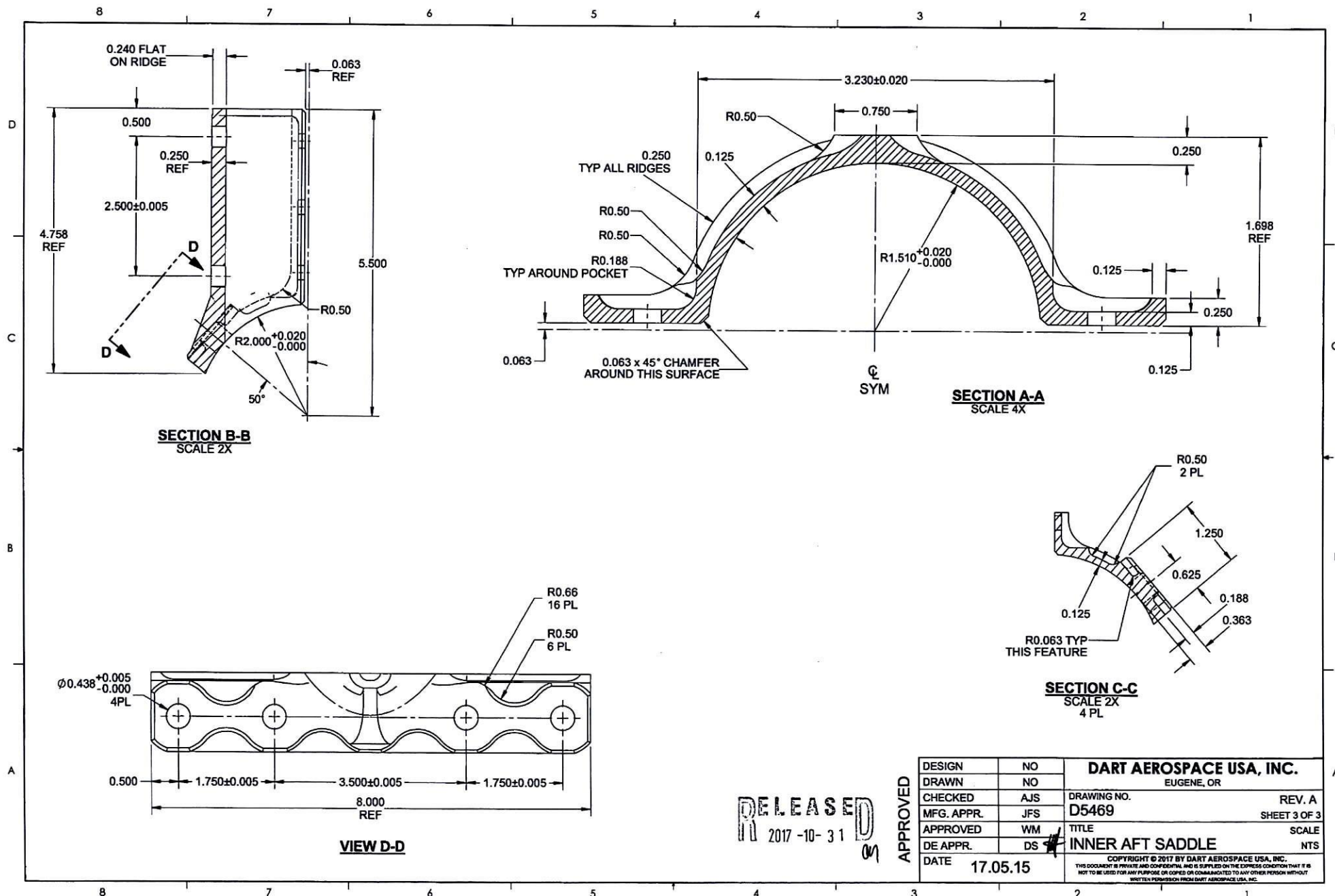
- 1) MATERIAL: 7075-T7351 PER QQ-A-250/12
REF DART SPEC. D6101-005
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5469-1" & BATCH NUMBER PER QSI 044 6.3
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
- 7) WEIGHT: 0.84 lbs
- 8) MASK THESE HOLES PRIOR TO PAINT

RELEASED
2017-10-31
EIN 17-726

APPROVED

A NEW ISSUE		NO	17.05.15
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5469	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	INNER AFT SADDLE	NTS
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RELEASED
2017-10-31

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5469	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
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1/31/2018

Print

Purchasing Receipts



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-6200

PO No	Supplier	Line Item No	Rel No	Terms	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Received Quantity	Accounting Job No	Serial No	Status	Receive Date	Price/Unit	Aging Days	Past Due	Total	Suppl Nam
PO038908	ATE003-VC	1	1	Net 30	OUTSIDE SERVICES	paint white D5425-043 job 168535				1	1/31/2018	1			Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Deboss
		2			paint white D5425-043 job 170125					1		Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Deboss			
		3			paint white D5466-1 job 171077			2		2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		4			paint white D5469-1 job 171080					2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		5			paint white D5468-1 job 171079					2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
		6			paint white D5467-1 job 171078					2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Deboss			
Total:										10		10								\$528.86	

Plex 1/31/2018 11:23 AM dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038908**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038908
PO Date: 1/30/18
Due Date: 1/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		Paint	OUTSIDE SERVICES	paint white D5425-043 job 168535	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
2		Paint	OUTSIDE SERVICES	paint white D5425-043 job 170125	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
3		Paint	OUTSIDE SERVICES	paint white D5466-1 job 171077	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
4		Paint	OUTSIDE SERVICES	paint white D5469-1 job 171080	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
5		Paint	OUTSIDE SERVICES	paint white D5468-1 job 171079	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
6		Paint	OUTSIDE SERVICES	paint white D5467-1 job 171078	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
Grand Total:										\$650.00	

Order Notes

CL

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